

Work Order ID 68643

Tuesday, April 19, 2011 12:55:43 PM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 4/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-04-19

Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DC

DOCUMENT CONTROL

0.00

Document Control

MemoIf D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004*n/a*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68643

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Page 2

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Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Float Skidtube

Start Date: 4/19/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R ☐ Sikaflex-241/-291 ☐ M116198
Expiry date: ☐ 12/06

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 ☐ M1116198
Expiry date: ☐ 12/06

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/R ☐ LPS Procyon ☐ M114256

1 0 11/04/29

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Page 3

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Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S uluclz9

Memo

0.00

FD

130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

0.00

0.00

PPP

62579

11/4/29 SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/04/29

MF
11-04-29

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 19, 2011 12:55:37 PM

Page 1

Work Order ID: 68643

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube



Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A		Purchased	No			110	Each	2,358.000	24	24			
BOLT													

Location	Loc Qty	Loc Code
ST350	2358	
116924	358	
117094	1000	
117313	1000	

AN3C6A		Purchased	No			110	Each	224.0000	12	12			
BOLT													

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	223	
111982	2	
116419	71	
116549	50	
116704	100	

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Picklist Print

Tuesday, April 19, 2011 12:55:38 PM

Page 2

Work Order ID: 68643

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No
BOLT

110 Each 171.0000 8 8

Location

Loc Qty

Loc Code

ST351

171

113149

30

116169

41

117313

100

AN960C10L NAS1149C0332 R Purchased No

110 Each 0.0000 44 44

washer D3391-021 Manufactured No

110 Each 0.0000 1 1

Fwd Tube Assembly D3391-023 Manufactured No

110 Each 0.0000 1 1

Mid Tube Assembly D3391-025 Manufactured No

110 Each 1.0000 1 1

Aft Tube Assembly

Location

Loc Qty

Loc Code

FP

1

48122

1

Tuesday, April 19, 2011 12:55:38 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 68643

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-1

Manufactured No

110

Each

17.0000

1



Wearshoe

Location

Loc Qty

Loc Code

FG

2

33798

2

FP019

15

58823

1

64747

14



11/04/29

D3564-3

Manufactured No

110

Each

14.0000

1



Wearshoe

Location

Loc Qty

Loc Code

FG

2

33764

2

FP019

12

62835

3

64748

5

66000

4



11/04/29

D3564-5

Manufactured No

110

Each

24.0000

1



Wearshoe

Location

Loc Qty

Loc Code

FG

2

34806

2

FP019

22

66551

10

67588

12



11/04/29

Tuesday, April 19, 2011 12:55:38 PM

Shop Packet Print

Page 3

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Picklist Print

Tuesday, April 19, 2011 12:55:38 PM

Page 4

Work Order ID: 68643

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube



Start Date: 4/19/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-1

Manufactured No

110

Each

36.0000

2

2



Gasket



11/04/24

Location

Loc Qty

Loc Code

FP015

36

68344

36

X8

D3566-5

Manufactured No

110

Each

27.0000

1

1



Gasket



11/04/24

Location

Loc Qty

Loc Code

FP015

27

66552

5

67589

22

X1

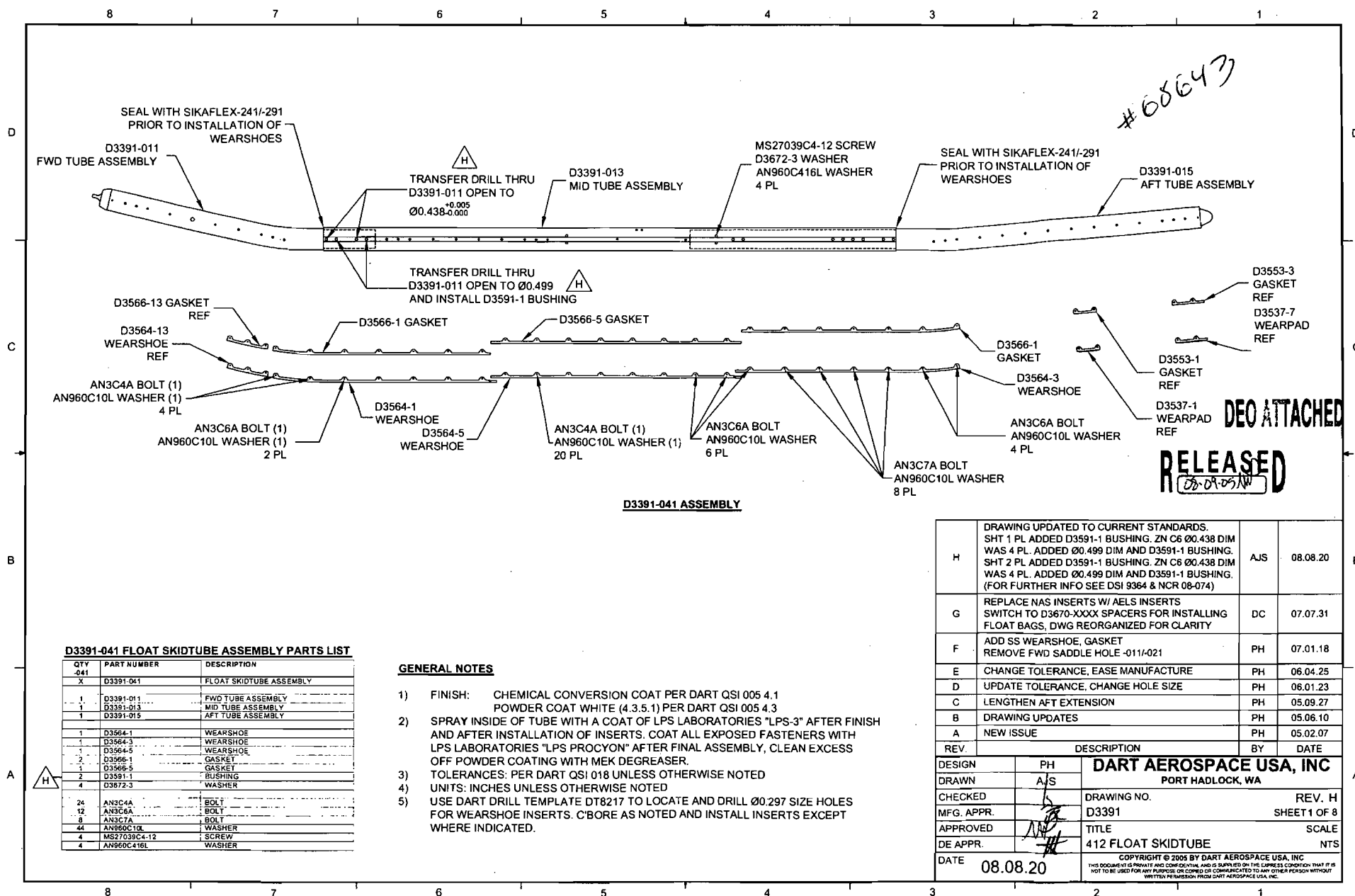
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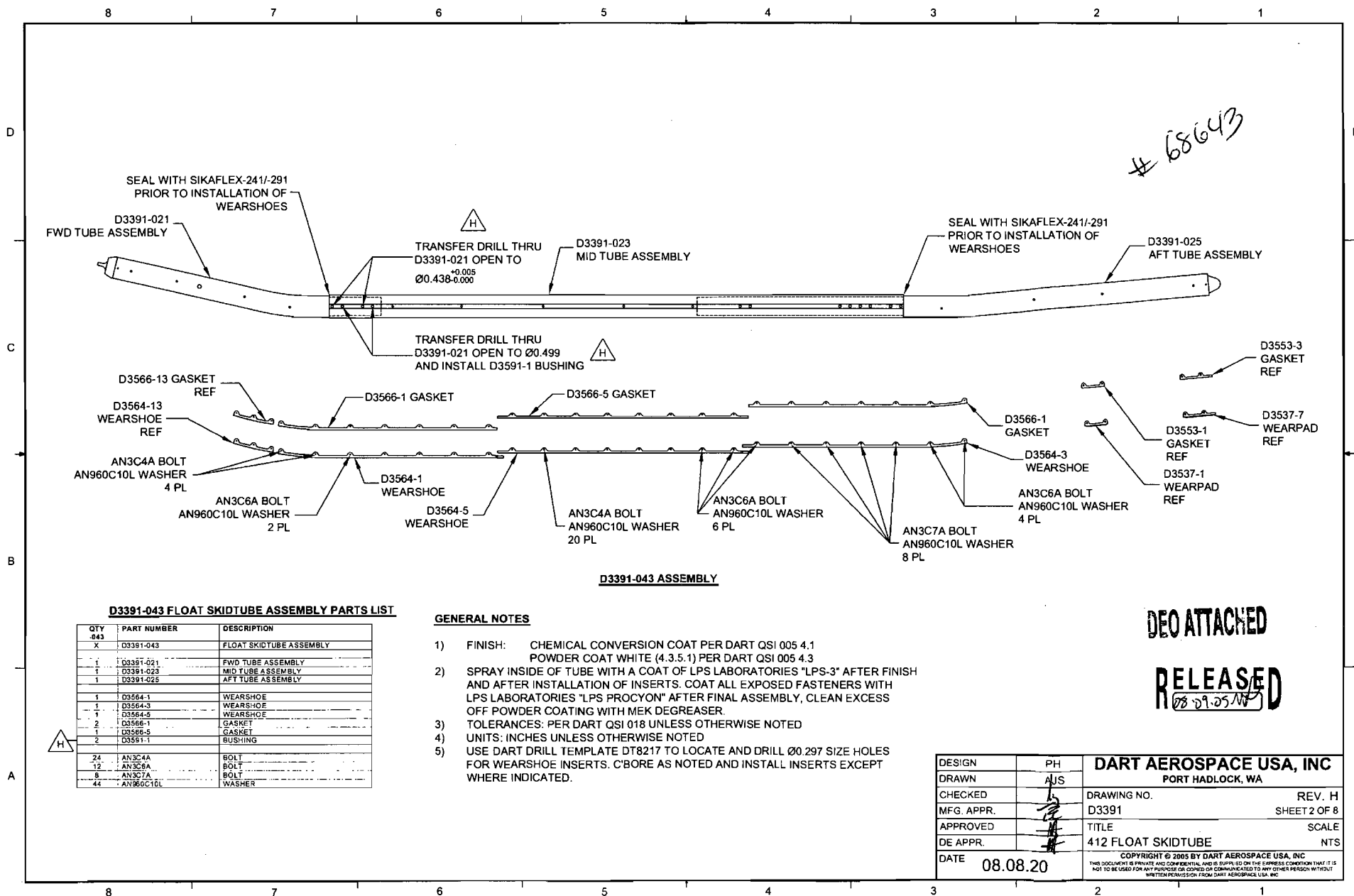
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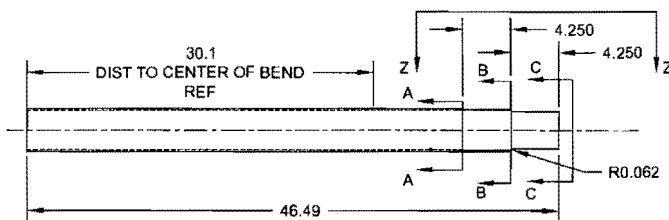
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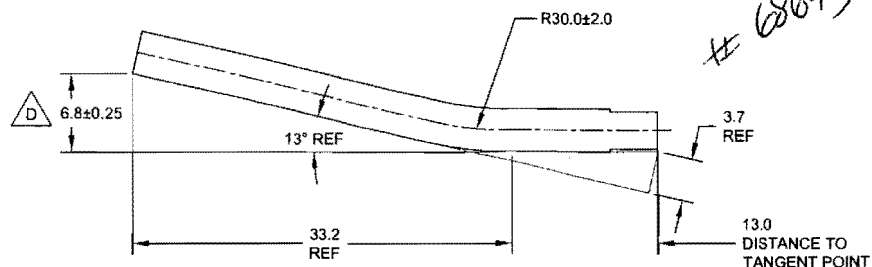
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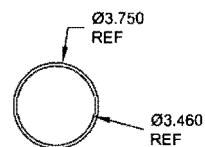
NOTE: Date & initial all entries



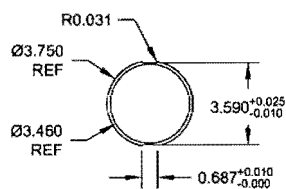
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



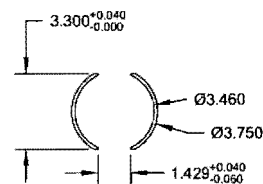
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



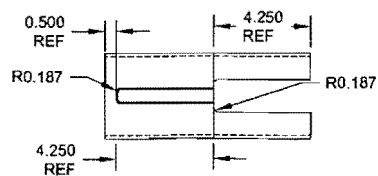
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
68643

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

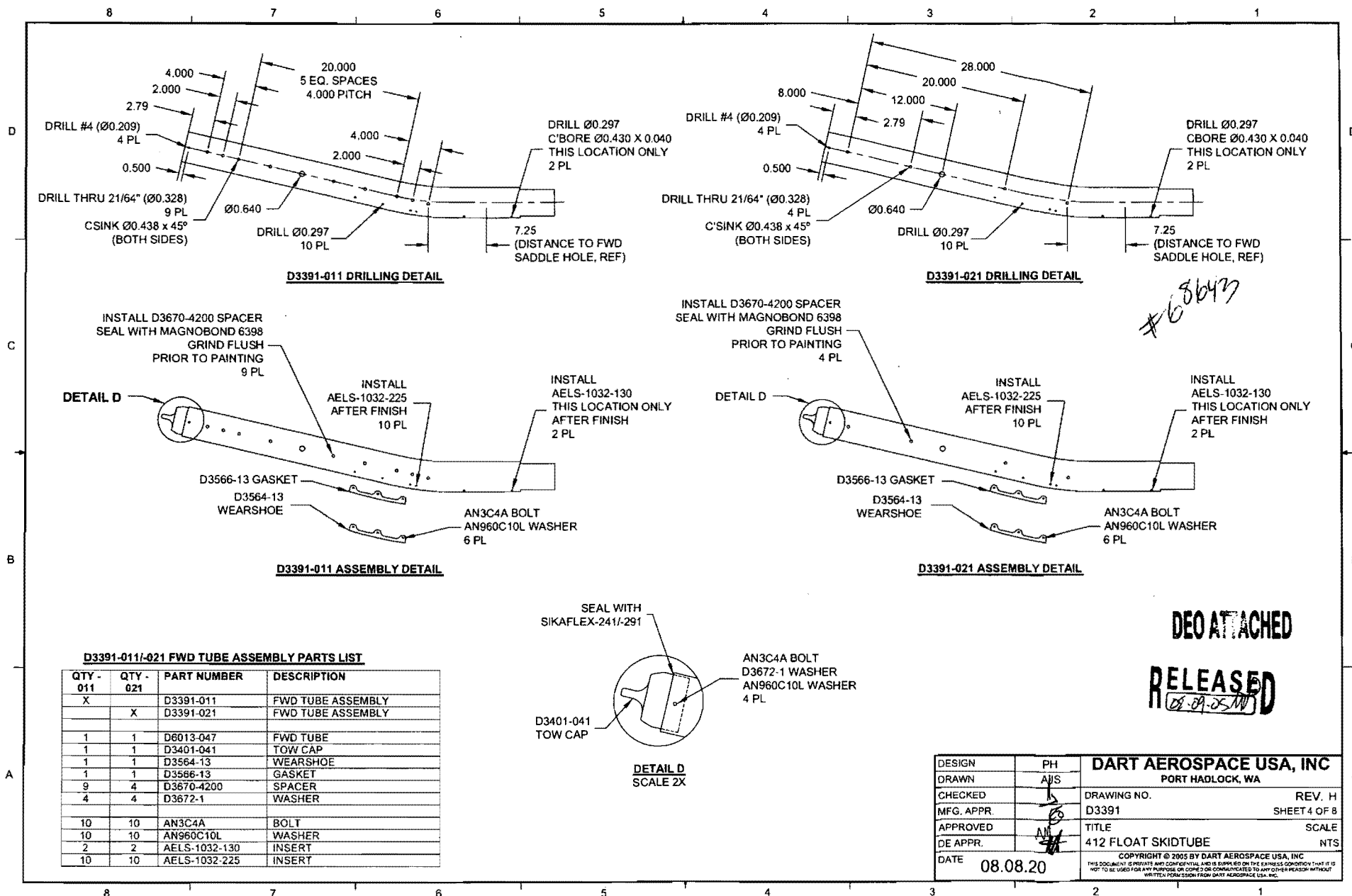
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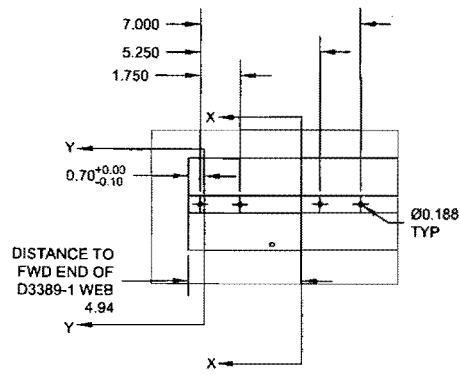
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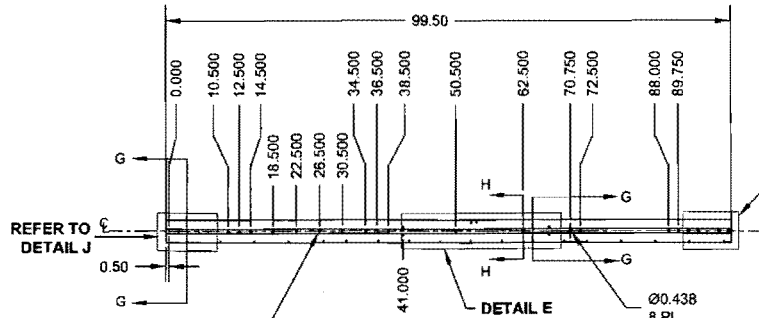
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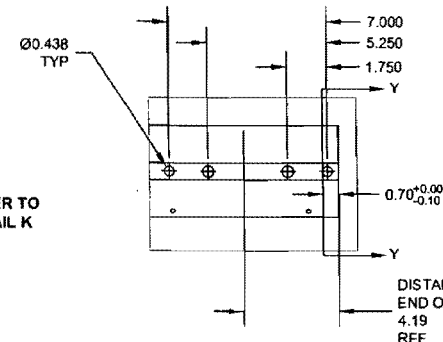


DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



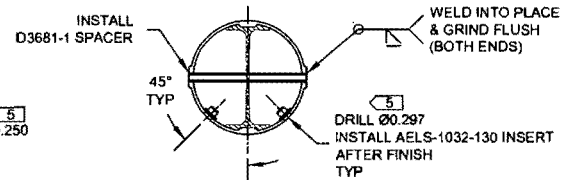
D3391-013 ASSEMBLY DETAIL



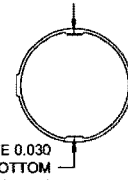
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SCALE 4X



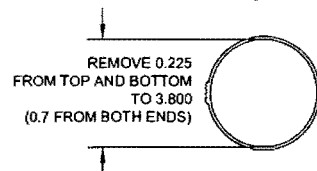
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



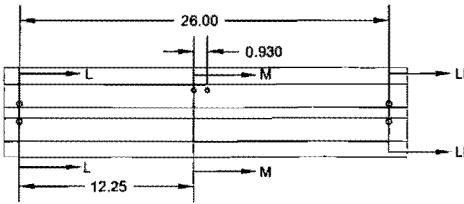
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SCALE 5X



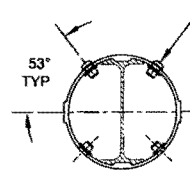
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

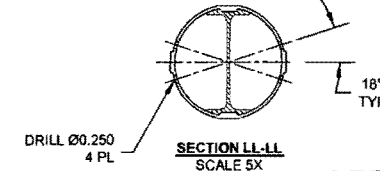


DETAIL E
SCALE NONE



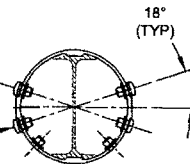
SECTION M-M
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



SECTION LL-LL
SCALE 5X

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



SECTION L-L
SCALE 5X

DEO ATTACHED

RELEASED

DESIGN		PH	DART AEROSPACE USA, INC	
DRAWN		ALIS	PORT HADLOCK, WA	
CHECKED			DRAWING NO.	REV. H
MFG. APPR.			D3391	SHEET 5 OF 8
APPROVED			TITLE	SCALE
DE APPR.			412 FLOAT SKIDTUBE	NTS
DATE		08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

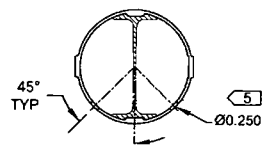
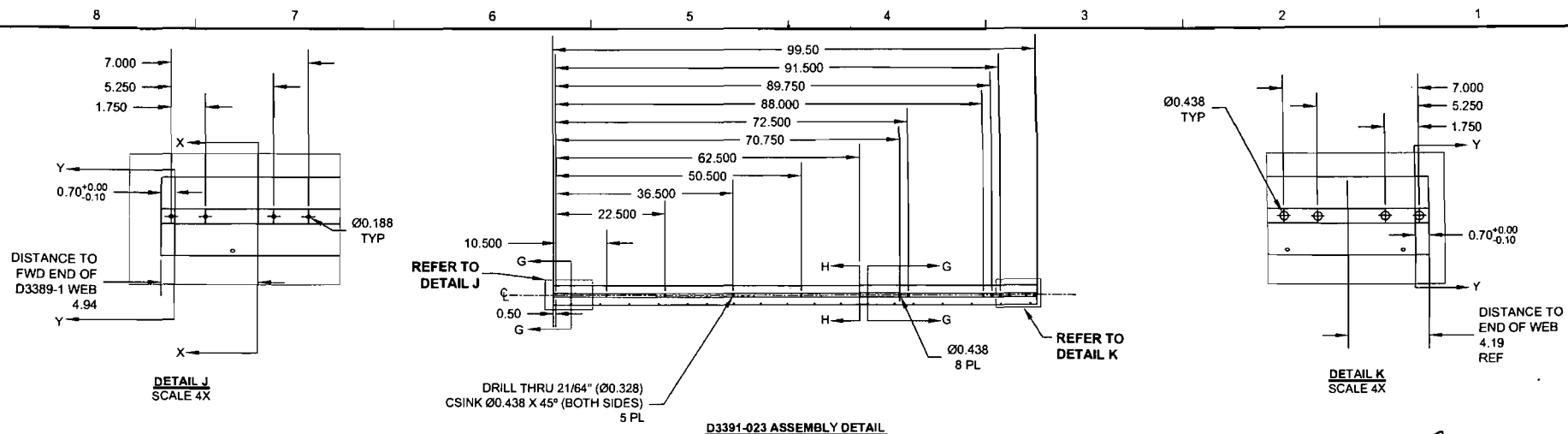
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

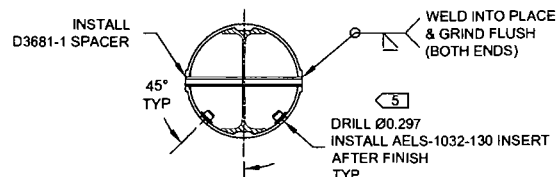
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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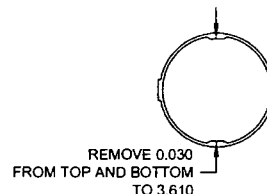
NOTE: Date & initial all entries



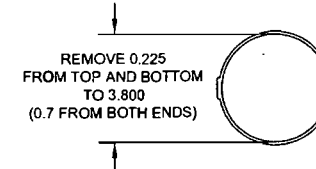
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

DEO ATTACHED
RELEASED
08/08/20

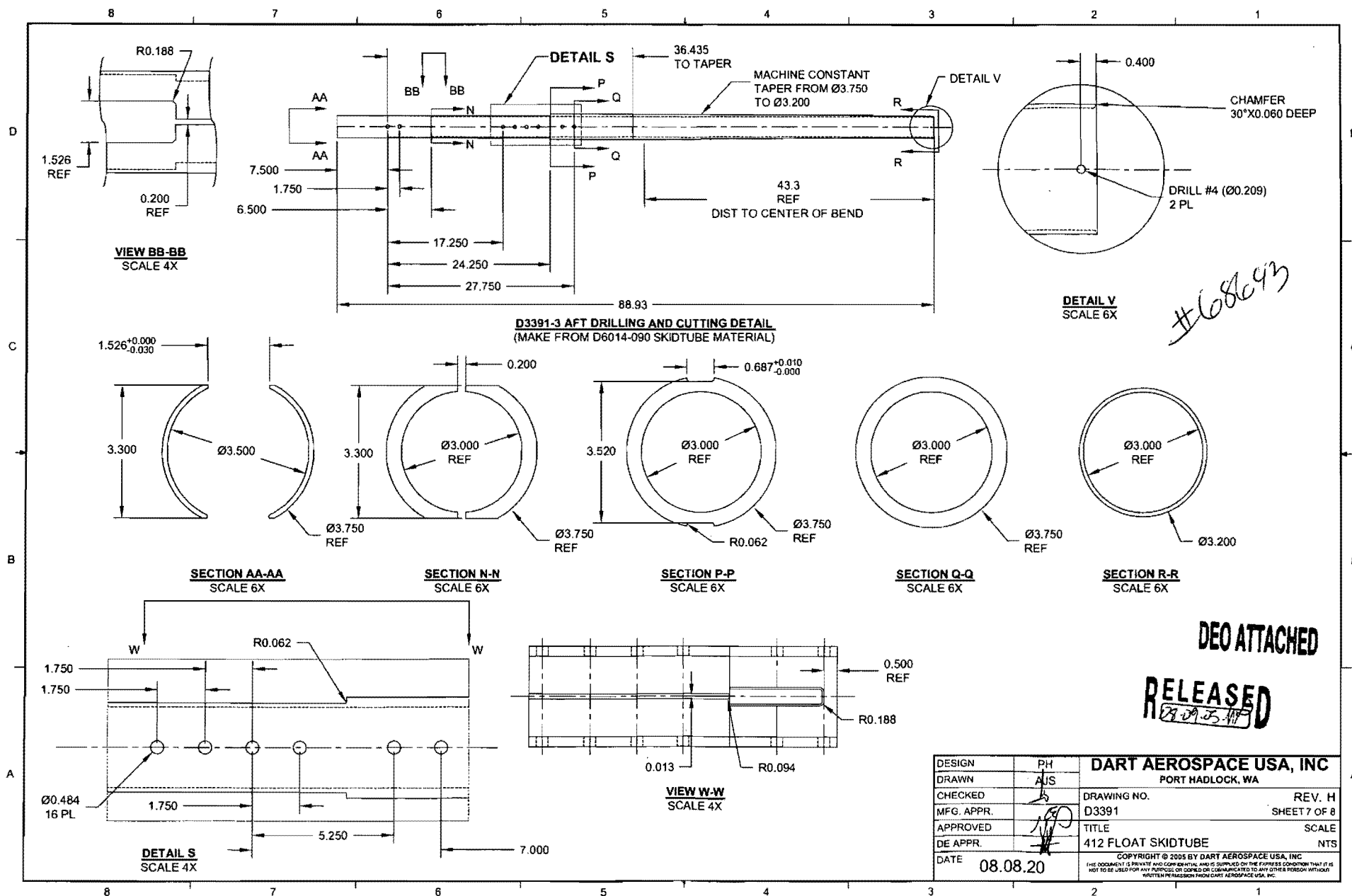
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



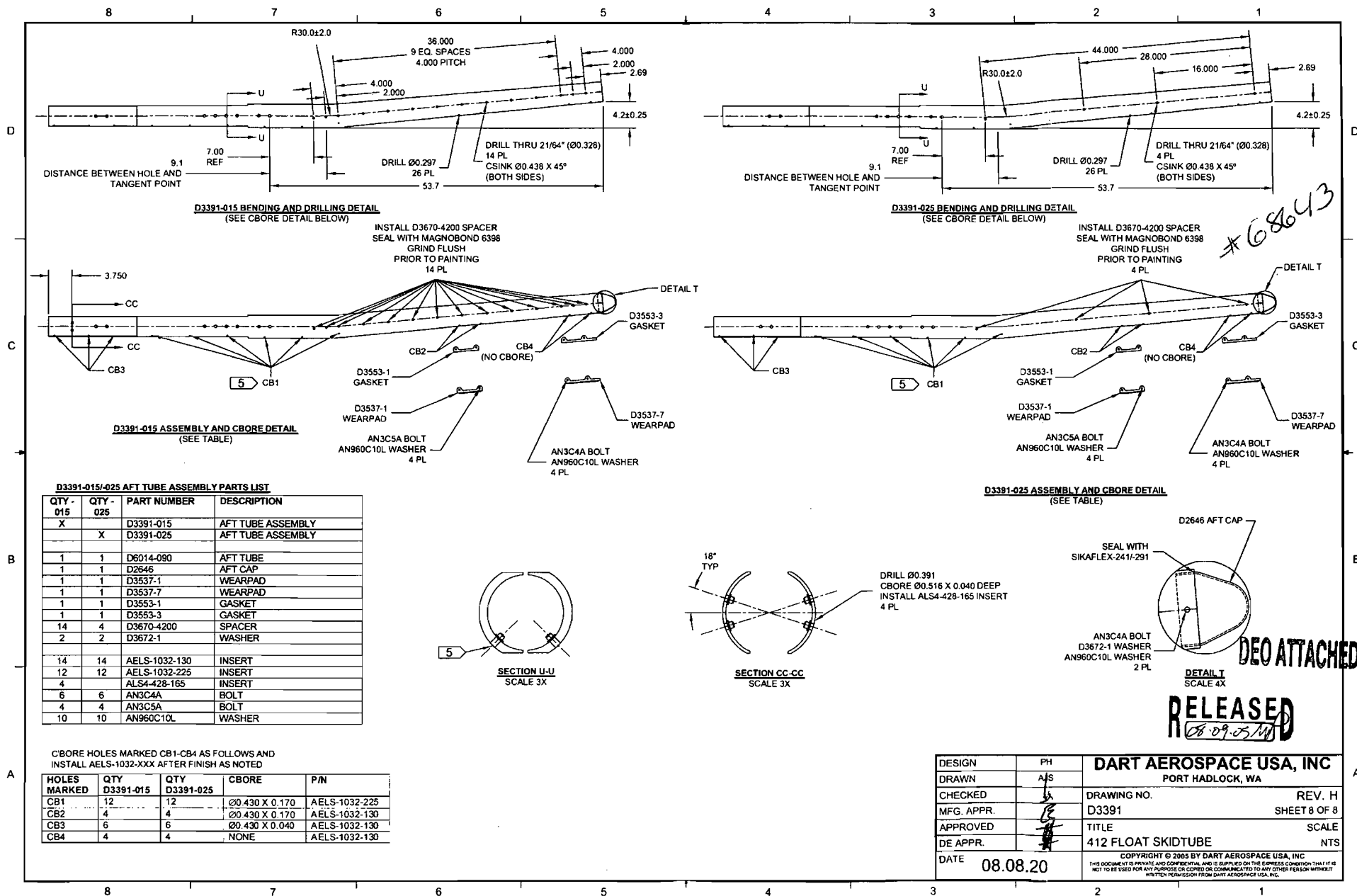
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>h</i>	MFG. APPR. <i>M</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

#658647

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries